

Work Order ID 73064

Thursday, August 25, 2011 7:15:18 AM

Page 1

Item ID: D2525-3

Accept

Revision ID:

Item Name: Spacer

Start Date: 8/25/2011 Start Qty: 4.00

Required Date: 8/31/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:  Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2525	Rev B

100



Lathe Conv

Conventional Lathe


CONVENTIONAL LATHE

Memo

Turn as per Dwg D2525

0.00

0.00

 11/08/29

4

110



QC


Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

 11/08/29

4

120



QC


Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

 11/08/29

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2525-3

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Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 8/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4X Ø M-11/02/30

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/8/30

150

Identify as per dwg & Stock Location: ST 16

0.00



Packaging

Memo

0.00

Packaging

11-08-30

11-08-30

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Start Date: 8/25/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/8/30
MR
11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

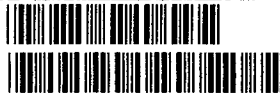
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Page 1

Work Order ID: 73064

Parent Item: D2525-3

Parent Item Name: Spacer



Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B[199.11.10] Re-format added Acid etch step[TEC]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	32.9730	0.022	0.092632			



6061-T6 Round Bar .750"



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT013	32.973	
112442	0.796	
116406	0.617	
117481	12.76	
118106	18.8	

12 ~~AD~~ 11/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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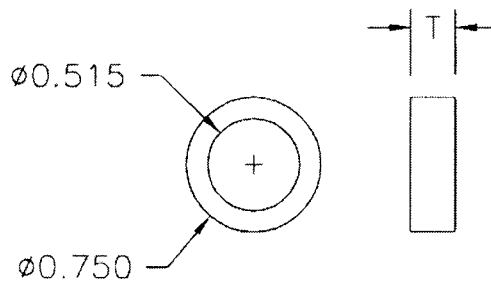
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY 77	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 77	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
49 12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



73064

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1